

Date: Tuesday, 4/17/2007 3:09:08 PM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SPACER
Job Number	31941		
Estimate Number	11167		
P.O. Number	N/A	Part Number	D32783
This Issue	4/17/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3278 REV B
First Issue	N/A	Project Number	N/A
Previous Run	31704	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By		Due Date	5/10/2007
Comment	Est. A 04.04.19 New issue KJ/JLM	Qty:	50 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINS0125X300	Black Delrin	
	Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.8060 sf(s)		
	Black Delrin		
	Use DT8685 Router Table.		
	Material: Black Delrin/UHMW 0.125" thick		
	(M-DELRIN-S0.125x30.0)		
	Identify for D3278-3		
	Batch: m15607 ml 07 04 25		
2.0	WATER JET	FLOW WATER JET	
	Comment: FLOW WATER JET		
	1-Cut as per Dwg D3278		
	Dwg Rev: B		
	Prog Rev: B		
	2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	ml 07 04 25		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 31941

Part Number: D32783

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

XSD

2-Deburr

ml 07/04/26

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DB 07/04/27 (SO)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

07/04/26 7/4/26 SO

SO

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(SO)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

Job Completion



U 07/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31941
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	M. M	Audited by:	A	Prototype Approval:	N/A
Date:	07-04-25	Date:	07/04/25	Date:	N/A

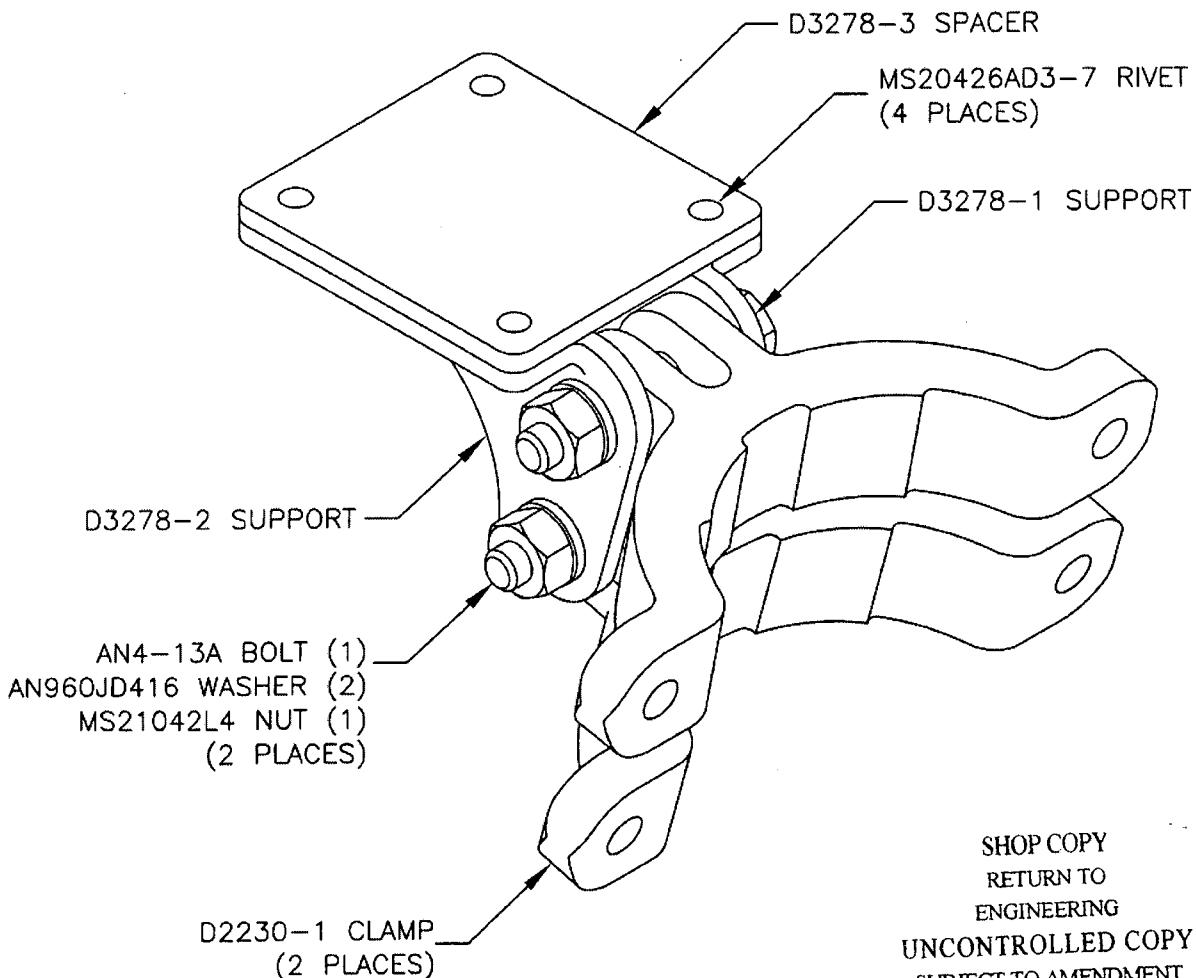
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM	SPD



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



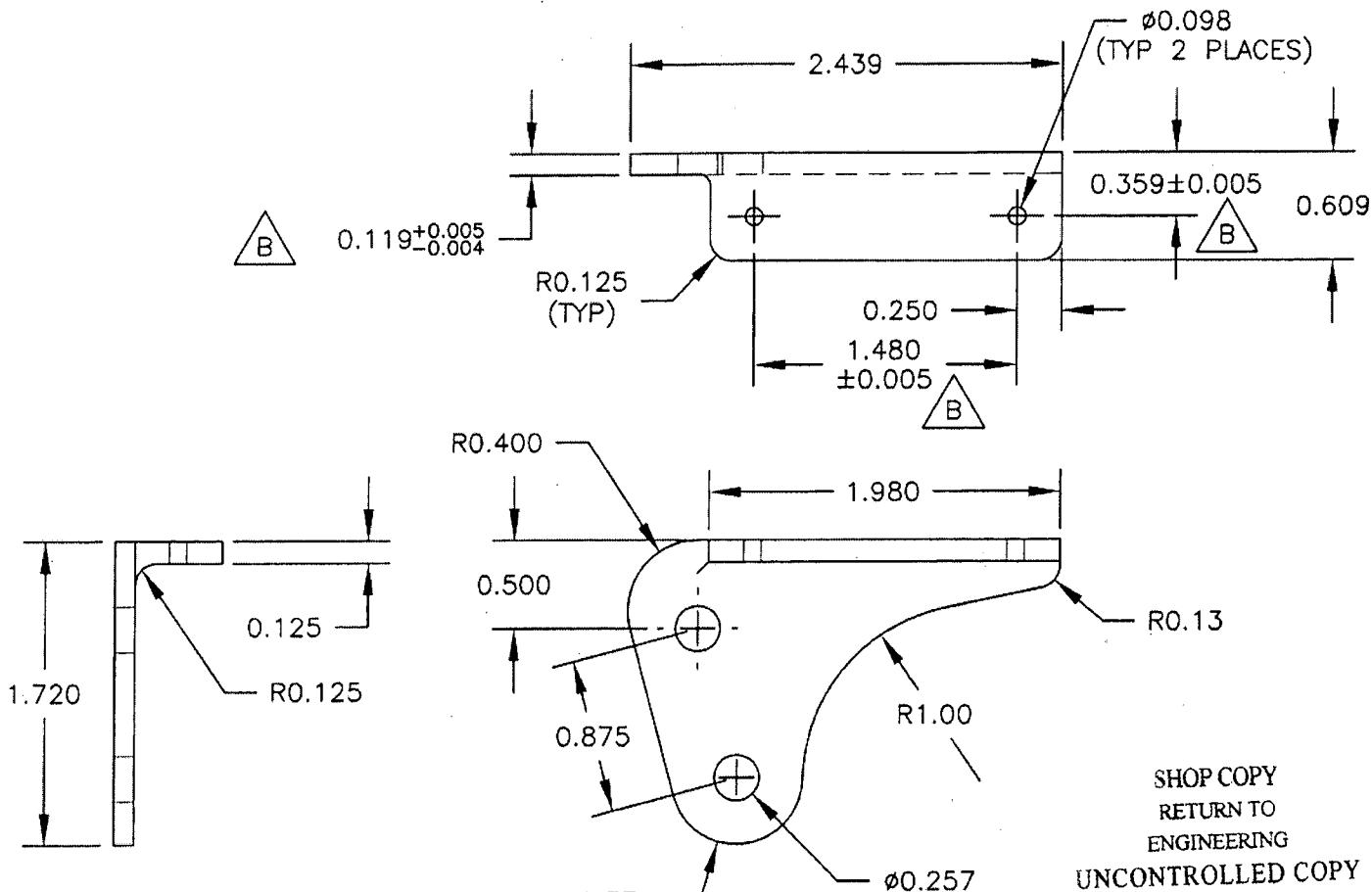
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WORK ORDER  
NO. 31941

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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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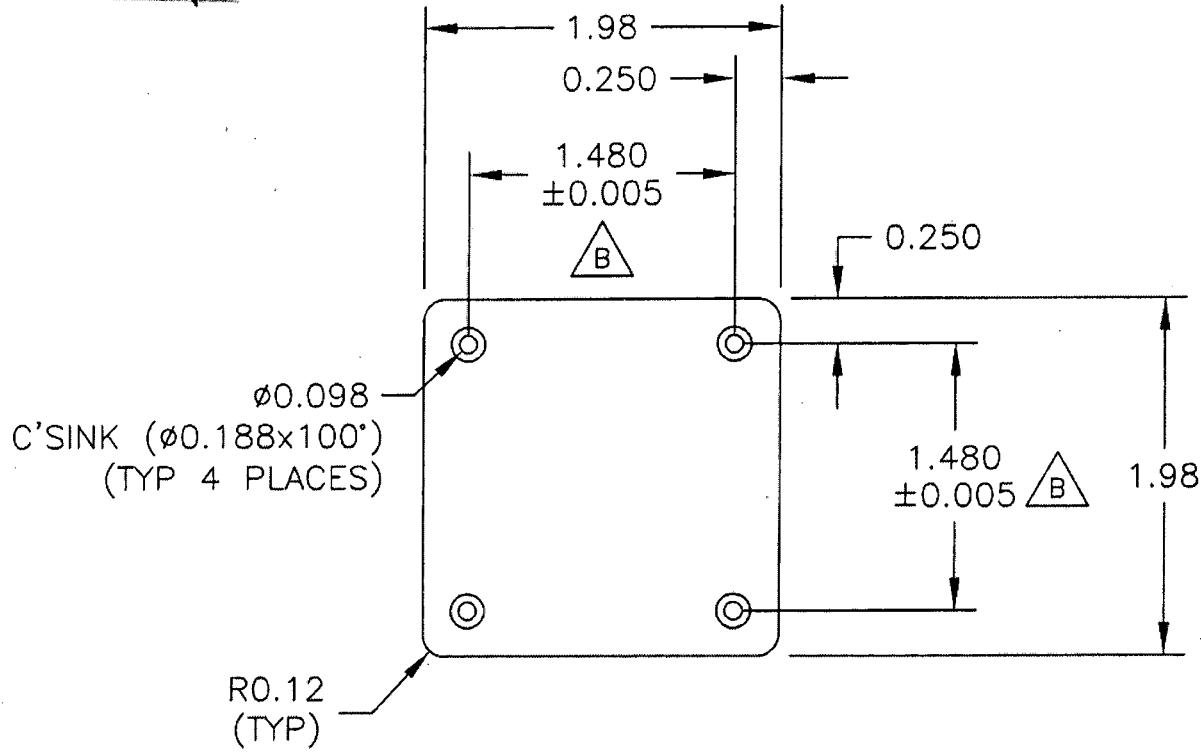
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NO. 31941

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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 3 OF 3 SCALE 1:1

RELEASED

05.04.04 *[initials]*

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WORK ORDER  
NO. 31941

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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